Work Ord April-11-13 9:4		861		*98	₹861*							Page	1
Item ID: Revision ID:	D4078-1			Accept	*N900	040	100)*	Setup	Start	*N.	S1*	
Item Name:	Clamp Half									Stop	*N.	S2*	
Start Date: Required Date: Reference:	3/27/13 : 4/10/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:							***
Approvals:	Process Pla	n: MC5	Date: 13-64- 1/	Tooling:	Da	ate:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):		ite:				Stop	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hour	Tool ID	Tool #	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp	
Draw Nbr	Rev	ision Nbr									·		
D4078	В											<u></u>	
*100 *100* Bandsaw Jeaspa Bandsaw		Memo Cut blank 2.	700" long	0.00 0.00	Up= 2013-04	-16		90	(b	. 18		
					•				•				
110		-		0.00				0Ac					
110 HAAS 1 HAAS CNC vertical	l machine #1	Memo Mill as per D Folio rev: Dwg Rev:	owg and Folio FA929	0.00			ی	OZZ-T	<u> </u>	_1_3:	- 54 -	-(8	× 2.0
		5.	· ·	·	•	:							

Deburr

April-11-13 9:47:56 AM

Item ID:

D4078-1

Accept

N900040100

Setup Start

Start Qty: 20.00

Cust Item ID:

Customer:

Tool ID

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling:

SPC (Y/N):

Date:

Date:

Run

Stop

Sequence ID/ **Work Center ID** 120

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours** 0.00

Tool # Plan Code

Accept Qty

Reject **Qty**

Reject Insp.

Number Stamp

120

QC Quality Control

0.00

130

QC Quality Control

Memo

QC8- Inspect parts - second check

Memo

0.00

0.00

F.K 13/04/19

140

Chemical Conversion Coat per QSI005 4.1

0.00

140 HandFinish

Hand Finishing

Memo

0.00

Revision ID:

Item Name: Clamp Half

Start Date: 3/27/13

Required Date: 4/10/13

Date:

Req'd Qty: 20.00

Page 3

160 QC3-Inspect Part Finish 0.00 *160* 20 d 13-4-22	April-11-13 9:47:56 A	1 <i>pril-</i>	April-11-13	9:47:56 AM			900	SO I				rage)
Start Date: 3/27/13 Start Qty: 20.00 *20* Cust Item ID:	Revision ID:	Revis	Revision ID:				Accept	*N900040	1100*	Setup		*NS1*	
Approvals: Process Plan: Date: Tooling: Date: Stop * NR7* Sequence ID/ Work Center ID	Required Date: 4/10/1	Requi	Required Da		- •							14(1)	
Work Center ID Description Run Hours Code Qty Qty Number Stamp Number Stamp		\ppr	Approvals:							Run		*NR1* *NR2*	
160 QC3- Inspect Part Finish 0.00 *160* 20 db 13-44-22	Work Center ID 150 *150* Powdercoat Powder Coating	Vork 50 * 1 Powder	Work Center 150 *150* Powdercoat Powder Coating	r ID	Description Black Sandtex(Ref:4.3.5.7	() per QSI005 4.3	Run Hours						2
QC Memo 0.00 Quality Control	*160*	*16 QC	*160*				0.00		20	\$	/_	13-4-22	
170 *170* Packaging Memo Identify as per dwg & Stock Location: \$\frac{5}{100}\$ 0.00 Memo 0.00	*170* Packaging	* 1 7 Packag	*170* Packaging			k Location: <u></u> \$\forall \forall			(4)] [3/4]	, 122	(20)	

Picklist Print

April-11-13 9:48:01 AM

Work Order ID: 98861

Parent Item:

D4078-1

D4078-1

Parent Item Name: Clamp Half

Start Date: 3/27/13

Required Date: 4/10/13

Start Qty: 20.00

**

Required Qty: 20.00

Comments:

Ipp Rev: A New Issue 10-05-07 JLM Verified By: EC

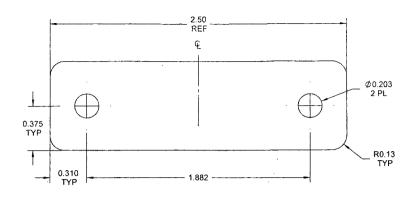
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X01.25		Purchased	No			100	f	41.0448	0.223	4.694737			

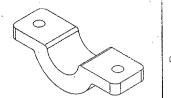
M6061T6R1 250X01 250

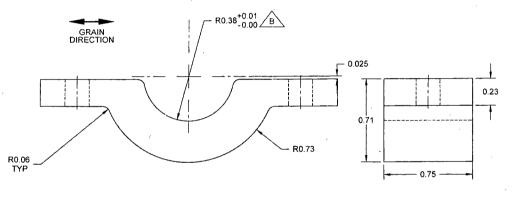
6061-T6 Bar 1.25 x 1.25

Location	Loc Qty	Loc Code	
MAT003	41.0448421		
122521	0.6638421		
123649	2.978		
124443	37.403		46947 OFC 15 2013-04-1

Page 1







D4078-1 CLAMP HALF

NOTES:
1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-220/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4078-1" USING WHITE FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.06 lbs

С

В	R0.38 w	R0.38 was R0.48.						
Α	NEW IS	SUE		₿₿	10.02.08			
REV.			DESCRIPTION	ESCRIPTION BY				
DESIG	Ň	(B	DART AERO	OSPACE L	TD			
DRAW	N	B	HAWKESBURY,	ONTARIO, CANA	DA			
CHECKED #5			DRAWING NO.		REV. B			
			D4078		SHEET 1 OF 1			
APPROVED APP			TITLE	SCALE				
DE APPR.			CLAMP HALF N					
DATE 10.07.30			COPYRIGHT © 2010 B THIS DOCUMENT IS PRIVATE AND COMPREHENT AN NOT TO BE USED FOR ANY PURPOSE OR COMED WRITTEN PERMISSION I	ND IS SUPPLIED ON THE EXPRES	S CONDITION THAT IT IS			

SEEST OF E RETURNED ENGINE ---UNCONTROL SUBJECT TO THE ST. WITH THE

DART AEROSPACE LTD	Work Order:	98861
Description: Clamp Half	Part Number:	D4078-1
Inspection Dwg: D4078 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	, J04		<u> </u>	vem	ZT -4
R0.13	+/-0.030	.130			Good	41
1.882	+/-0.010	1.879				
. 0.310	+/-0.010	309				
0.375	+/-0.010	. 309				
R0.06	+/-0.030	,060				
` R0.73	+/-0.030	.735				
R0.38	+0.010/-0.000	- 387	<u> </u>		h. \ \ \ n	31006
0.025	+/-0.010	.025			haltrage	
0.71	+/-0.030	.025				
0.75	+/-0.030	.750				
0.23	+/-0.030	.229				
			-			
		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,				
, , , , , , , , , , , , , , , , , , ,						
	<u> </u>					L

Measured by:	11/2	Audited by:	F.K.	Preliminary Approval:	
Date:	13-04-18	Date:	13/04/19	Date:	

Rev	Date	Change	Revised by	Approved
Α	10.10.07	New Issue	KJ KJ	1/2